



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2594-1
Job Sheet 175174



Part No: D2594-1

Job Qty: 300 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/28/18

Job Tracking No:

Due Date: 4/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP D 02.08.22 Make in Cobra KJ IPP E 06.12.11 ecn 836 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	300 Ea		4/19/18	0.00	0.00	Start Up Machining	27mL	JB 18-04-08
100	Hardinge	300 pcs		4/19/18	0.01	8.62	Hardinge	11	JB 18-04-08
110	QC	300 pcs		4/19/18	0.00	0.00	QC2	11	JB 18-04-08
120	QC	300 pcs		4/19/18	0.00	0.00	QC8		JB 18-04-08
130	HandFinish	300 pcs		4/19/18	0.00	0.69	HandFinish1		SA 18-04-09
135	Powdercoat	300 pcs		4/20/18	0.00	0.46	Powdercoat1	BR/	SA 18-04-12
150	QC	300 pcs		4/20/18	0.00	0.00	QC3		11 APR 12 2018
160	Packaging	300 pcs		4/20/18	0.00	0.00	Packaging3		9-89 APR 18 2018
170	QC21-SA	300 Ea		4/20/18	0.00	0.00	QC21		18/04/13

Part Op 100 - 1-Make as per Dwg D2594-1 and Folio FA262.

Descriptions: 135 - START TIME: 2:35

160 - LOCATION : FP001

OV. T. 500 FINISH: 8:05 M 138760

DAS
21
9-89

APR 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	15.6300 ft (.0521 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.625	16	44	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.060inches ± 0.005	0.065 0.055		
2	Plug	0.500inches ± 0.010	0.510 0.490		
3	Plug	0.625inches ± 0.010	0.635 0.615		
4	Plug	0.430inches + 0.000 - 0.002	0.430 0.428		
5	Plug	0.090inches + 0.000 - 0.002	0.090 0.088		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

6

Plug

0.045inches + 0.000
- 0.002

0.045
0.043

Plex 3/28/18 11:48 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐								
Date : _____		MRB (QSI042) Approval _____ _____								
Descripti Dart Aerospace Ltd. 1270 Aberdeen Street Markham, ON M6A 1K7 CANADA TEL: 1 913 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S059021 Part: D2594 - 1 Job No: 175174 Serial No/Batch: S059021 Revision: _____ Inspector: _____		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____								
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